

127966

Page 1

N900040100

Setup Start *NS1*

Stop *NS2*

30

30

Run Start *NR1*

Stop *NR2*

Date:

110		0.00	
110	HAAS CNC VERTICAL MACHINING #1		
HAAS 5AXIS	Memo	0.00	on 14/12/20 17
HAAS CNC vertical machine #5	1- Mill as per Folio FB353		
	DWG Rev: <u>A</u>		
	FOLIO REV: <u>AA</u>		
	2-Deburr per dwg		

Work Order ID 127966

127966

Page 2

December-18-14 1:21:21 PM

Item ID: D5101-041 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Crossbolt Spacer Assembly
 Start Date: 19/12/2014 Start Qty: 30.00 ***30*** Cust Item ID:
 Required Date: 23/12/2014 Req'd Qty: 30.00 ***30*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	QC2- Inspect parts off machine FAI/FAIB	0.00							
120									
QC	Memo	0.00				17	0		
Quality Control									
130	QC8- Inspect parts - second check	0.00							
130									
QC	Memo	0.00				17	0		DAS 37 9-89 15-01-16
Quality Control									
140		0.00							
140									
Small Fab	Small Fab	0.00				17	FF		JAN 2 6 2015
Small Fab	Memo	0.00							
Small Fab	INSTALL HELICOIL AS PER DWG .								

Work Order ID 127966

127966

Page 3

December-18-14 1:21:21 PM

Item ID: D5101-041 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Crossbolt Spacer Assembly
 Start Date: 19/12/2014 Start Qty: 30.00 *30* Cust Item ID:
 Required Date: 23/12/2014 Req'd Qty: 30.00 *30* Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
170	QC5- Inspect part completeness to step on W/O	0.00							DAS 38 9-89
170						(17)			
QC	Memo	0.00							
Quality Control									JAN 26 2015

180	Identify as per dwg & Stock Location: <u>St227B</u>	0.00							
180									
Packaging	Memo	0.00				17		ML3	15-01-26
Packaging									

190	QC21- Final Inspection - Work Order Release	0.00							
190									
QC	Memo	0.00							15/1/28
Quality Control									

(A) 51-27

Picklist Print

December-18-14 1:21:20 PM

Page 1

Work Order ID: 127966

127966

Parent Item: D5101-041

D5101-041

Parent Item Name: Crossbolt Spacer Assembly

Start Date: 19/12/2014

Required Date: 23/12/2014

Start Qty: 30.00

Required Qty: 30.00

Comments: IPP REV:A NEW ISSUE 14-12-18 JLM VERIFIED BY:DD

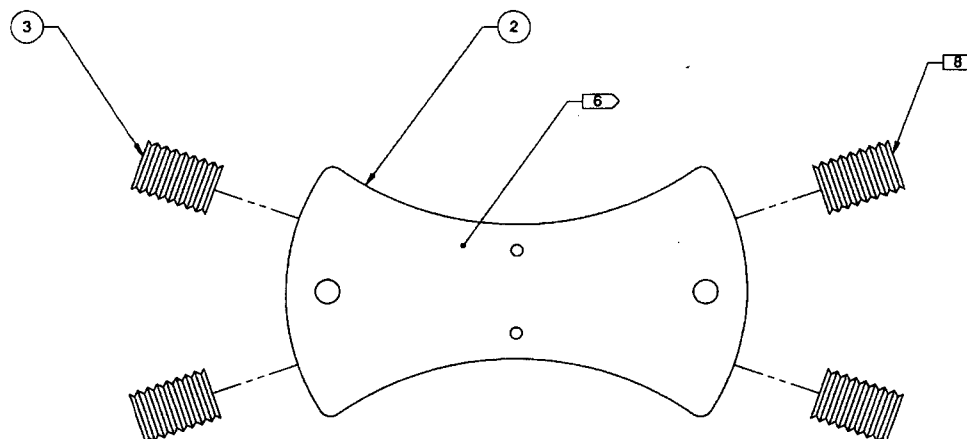
Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MDELRINB1.000X04.00		Purchased	No				f	3.9000		7			
MDFI RINB1 000X04 000										**	D.A 14/12/19		
Delrin Bar													
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				MAT011		3.9							
				→ 124382		2.9			2.9 ^{ff}				
				→ m128113		1			1.0 ^{ff}				
MS21209F7-15		Purchased	No				Each	0.0000		120			
MS21209F7-15										**	68 FF JAN 26 2015		
Heli-Coil, Locking													

DAS
08
9-89

2.9 ff
1.0 ff

131170

ITEM	QTY	P/N	DESCRIPTION
1	X	D5101-041	CROSSBOLT SPACER ASSEMBLY
2	1	D5101-1	CROSSBOLT SPACER
3	4	MS21209F7-15	HELICOIL, LOCKING



D5101-041 CROSSBOLT SPACER ASSEMBLY

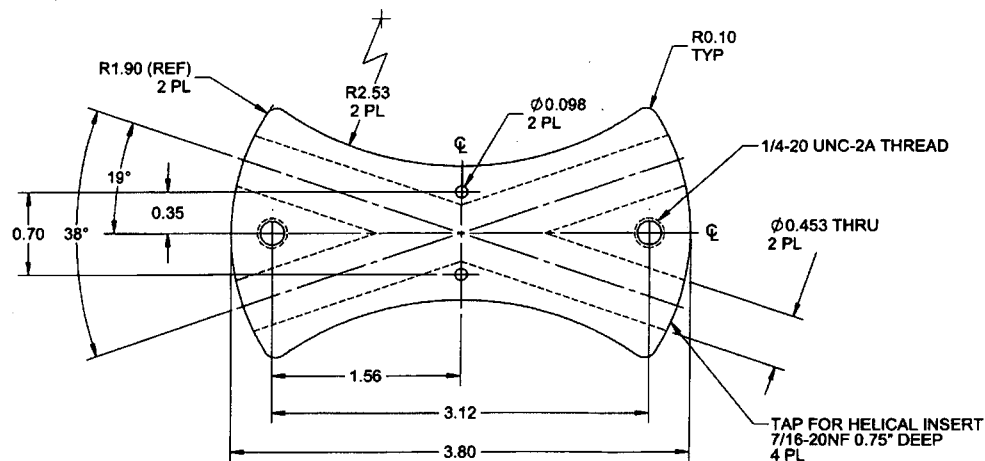
RELEASED

2014 NOV 24 9?
SEN 14-628

- NOTES:
- 1) MATERIAL: N/A
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: N/A
 - 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.6
 - 7) WEIGHT: 0.15 lbs
 - 8) INSTALL MS21209F7-15 HELICOIL FLUSH WITH ARC SURFACE

APPROVED

A	NEW ISSUE	AK	14.08.07
REV.	DESCRIPTION	BY	DATE
DESIGN	DC	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AK		
CHECKED	VS	DRAWING NO.	REV. A
MFG. APPR.	JLM	D5101	SHEET 1 OF 4
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	CROSSBOLT SPACER	NTS
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D5101-1 CROSSBOLT SPACER

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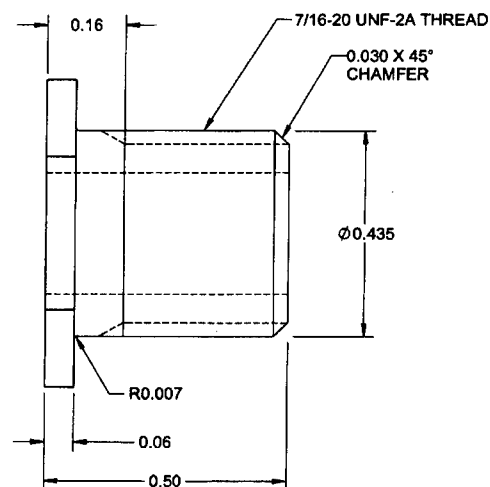
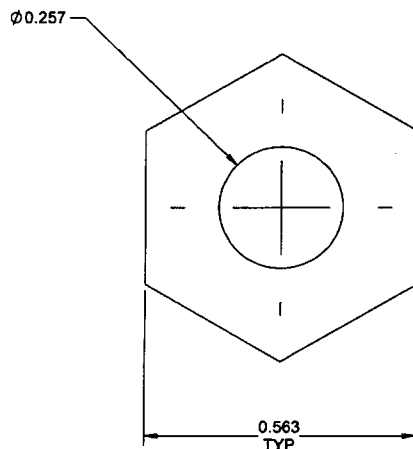
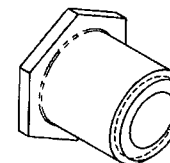
2014 NOV 24 *q*

NOTES:

- 1) MATERIAL: DELRIN II 150E OR ACETRON GP ACETAL
REF DART SPEC M-DELRIN-B
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.12 lbs

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D5101-3 INSERT

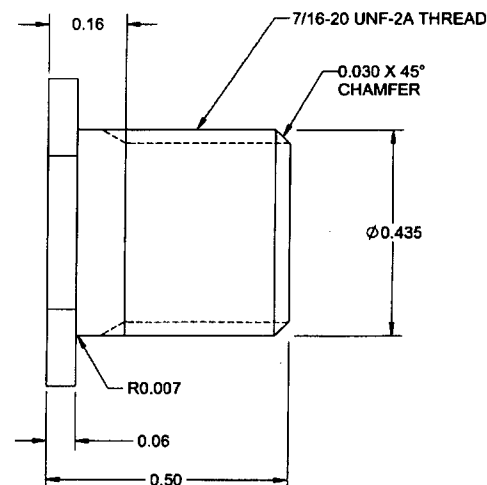
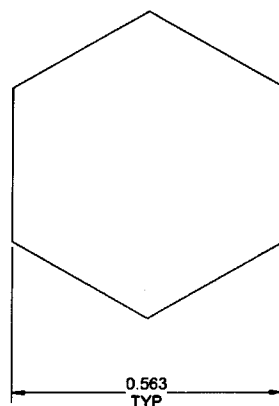
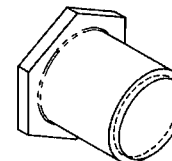
RELEASED

2014 NOV 24

- NOTES:**
- 1) MATERIAL: 6061-T6/T651/T6510/T6511/T62 ALUMINUM ROUND BAR
PER QQ-A-225/8 OR AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)
OR ASTM B211 OR ASTM B221
REF DART SPEC M6061T6R
 - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
 - 7) WEIGHT: 0.005 lbs

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D5101-5 INSERT

RELEASE

2014 NOV 24 4P

NOTES:

- 1) MATERIAL: 6061-T6/T651/T6510/T6511/T62 ALUMINUM ROUND BAR
PER QQ-A-225/8 OR AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)
OR ASTM B211 OR ASTM B221
REF DART SPEC M6081T6R
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 0.008 lbs

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DESIGN	DC	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
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